

Work Order ID 52034

September 14, 2009 10:23:32 AM



Page 1

Item ID: D2810-5 **BK** Accept

Revision ID: C/A1

Item Name: Strut

Start Date: 09/14/2009 Start Qty: 10.00

Required Date: 09/14/2009 Req'd Qty: 10.00

Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: *R/mt* Date: *09.9.14* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2810

Rev C

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per
Dwg D2810 and spec control Dwg D2727 using Jig DT8012

2-Deburr

M-L 09/10/01

(10X)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 09/10/01

(X/0)

/

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: *12:00*
OVEN TEMPERATURE: *300*
FINISH TIME: *12:30*

bk 09/10-5

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52034

September 14, 2009 10:23:32 AM



Page 2

Item ID: D2810-5

Accept



Setup Start



Revision ID: C/A1

Stop



Item Name: Strut

Start Date: 09/14/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

09/14/06 (10)

140

Identify as per dwg & Stock Location: 57265 0.00

Packaging

Memo

0.00

Packaging

09/14/06 (10)

150

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

09/10/06 MFMF
09-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 14, 2009 10:23:32 AM

Page 1

Work Order ID: 52034



Parent Item: D2810-5RevC/A1



Parent Item Name: Strut

Start Date: 09/14/2009

Required Date: 09/14/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	218.0731	20.1842			



304 RD Tube .500 x .035W



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

218.0731097

108250

2.23

111097

24.687936

111704

31.6682737

112187

159.4869

M-1 09/10/01

M112800 *

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

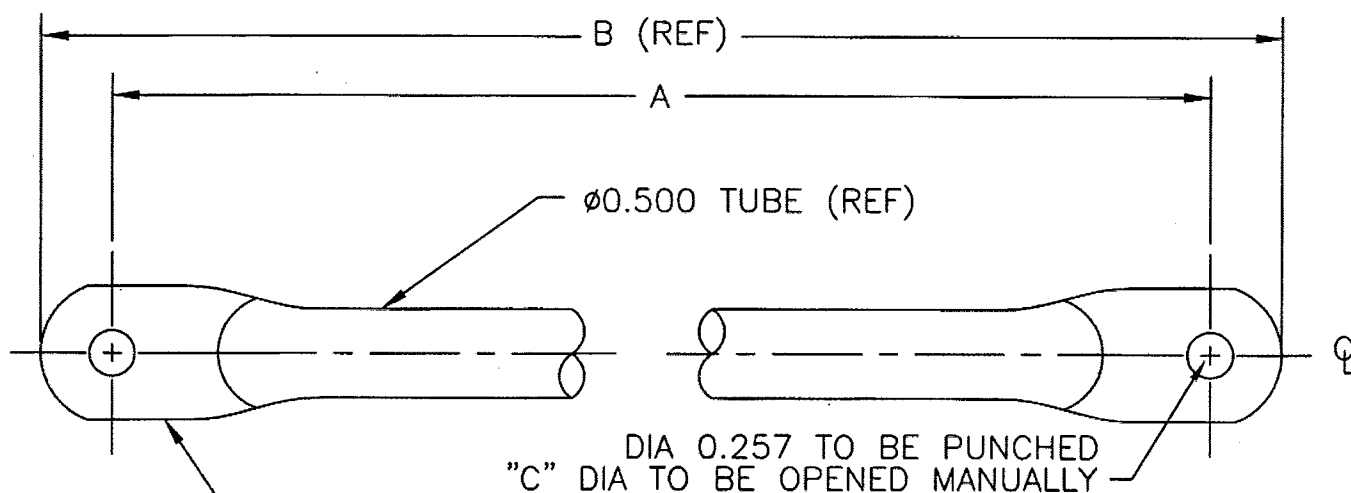
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2810	REV. C SHEET 1 OF 1
DATE 04.11.22		TITLE STRUT	SCALE NTS
A	00.11.08	NEW ISSUE	
B	03.09.11	ADD FINISH	
C	04.11.22	ADD -5	

RELEASE05.03.11 *[Signature]*

PUNCH ENDS PER
SPEC CONTROL
DRAWING D2727

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52034

PART #	A	B	C
D2810-1	25.33	26.13	N/A
D2810-3	24.60	25.40	N/A
D2810-5	23.01	23.81	0.266

D2810-1/-3/-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, $\phi 0.500 \times 0.035$ WALL (M304TR0.500W.035)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES

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